

Work Order ID 78723

January-13-12 7:09:48 AM

78723

Page 1

Item ID: D3140-241

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 12/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/01/13

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3140	Rev F
-------	-------

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3140 Dwg Rev: F Prog Rev: F 2-
Deburr if necessary

2024 0.00

6 0 Jm 12-8-18

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

6 0 Jm 12-8-18

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Smb
12 9 17

6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

January-13-12 7:09:48 AM

Page 2

NR2

Insp.
Stamp

Hand Finishing

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 78723

January-13-12 7:09:48 AM

78723

Page 3

Item ID: D3140-241

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 12/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

6x _____ SP
12/9/18

170

Identify as per dwg & Stock Location: **241A**

0.00

170

Packaging

Memo

0.00

Packaging

6 h SL 12/9/18

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/9/18 JH

MF
12-09-18

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

January-13-12 7:09:52 AM

Page 1

Work Order ID: 78723

Parent Item: D3140-241

Parent Item Name: Doubler

78723

D3140-241

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP A02.04.30New IssueNG
 IPP Rev B New dwg rev. ecn781 06.04.18 EC
 IPP Rev:C Now on Waterjet 06-06-08 JLM
 IPP rev.D added scuffing NCR 061 EC
 IPP Rev:E As per ECN #829 06-11-20 JLM
 IPP Rev:F now on water jet 08-01-15 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.020

Purchased

No

100

sf

75.0000

1.0782

~~6.809684~~

**

7.0

M2024T3S 020

Alum. sheet .020

JM 12-8-16

Location

Loc Qty

Loc Code

MAT022

75

103504

27

117684

48

103504
~~117684~~

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED H	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED

06.11.13

SHOWN BY

REV. F

ENCLOSURE

UNCONTROLLED COPY

SUBJECT TO DRAWING

WITH

NO

78723 M.L.J
12/01/13

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1



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78723

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[illegible]

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SECTION B-B

D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
 (WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

Three triangles are shown, labeled 1, 2, and 3 from left to right. Each triangle is an isosceles triangle with its base horizontal. Triangle 1 has a small square at its top vertex, indicating a right angle. Triangle 2 has a small square at its bottom-left vertex, indicating a right angle. Triangle 3 has a small square at its bottom-right vertex, indicating a right angle.

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DART AEROSPACE LTD.

DESIGN

[illegible]

CHECKED	DATE
---------	------

1.

DATE _____

06 10

DRAWN BY

CB

APPROVED

15

[illegible]

E761 / 778

3 PLY
OUT OUTER

OUTER SHELL

DRAWN BY

CB

APPROVED

15

[illegible]**DART**

DART AEROSPACE LTD.

DRAWING NO.

D3140

TITLE	
1	1

DOOR

REV. F

SHEET 3 OF 7

SCALE

SCALE
AREA

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

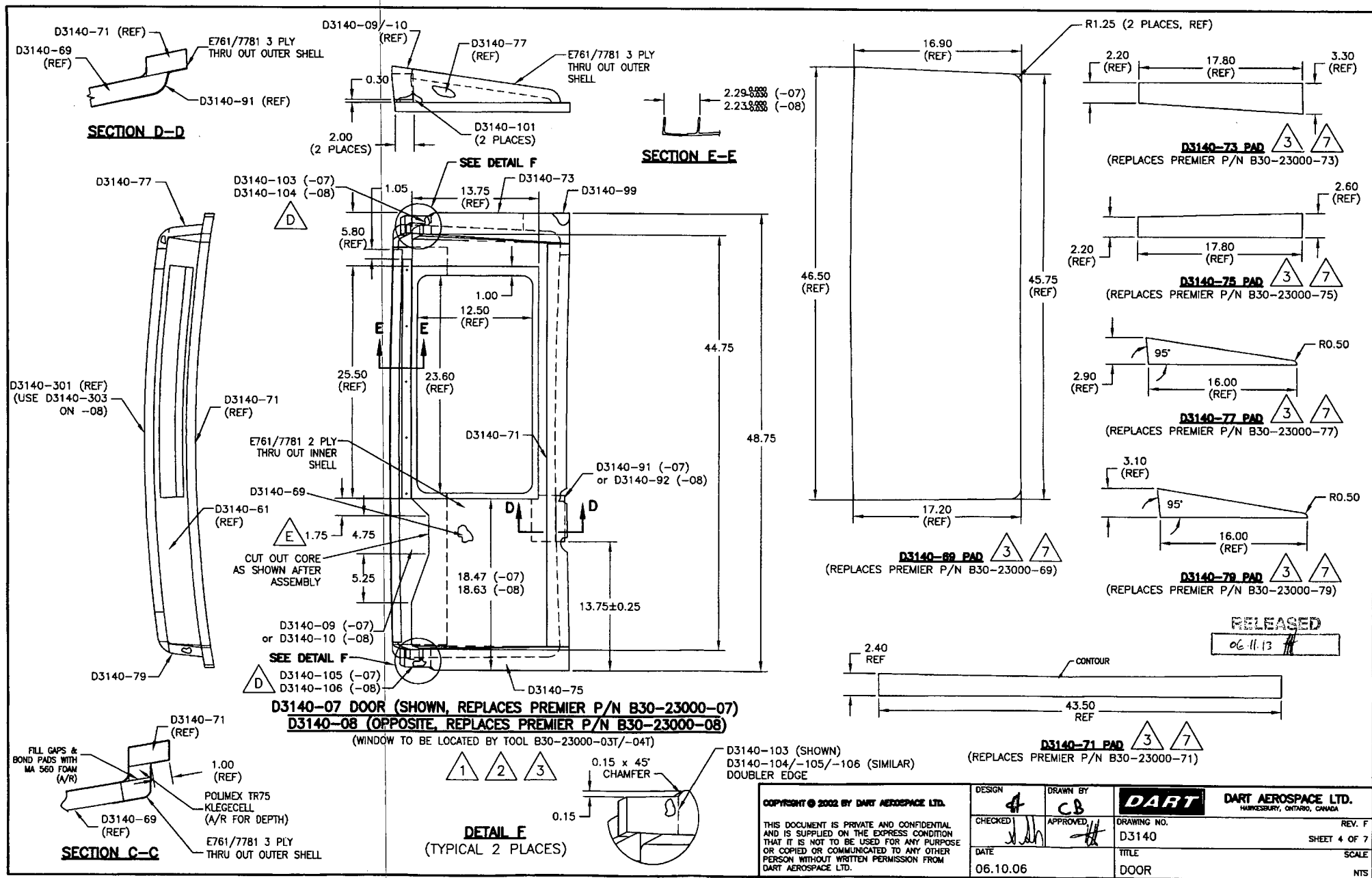
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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78723



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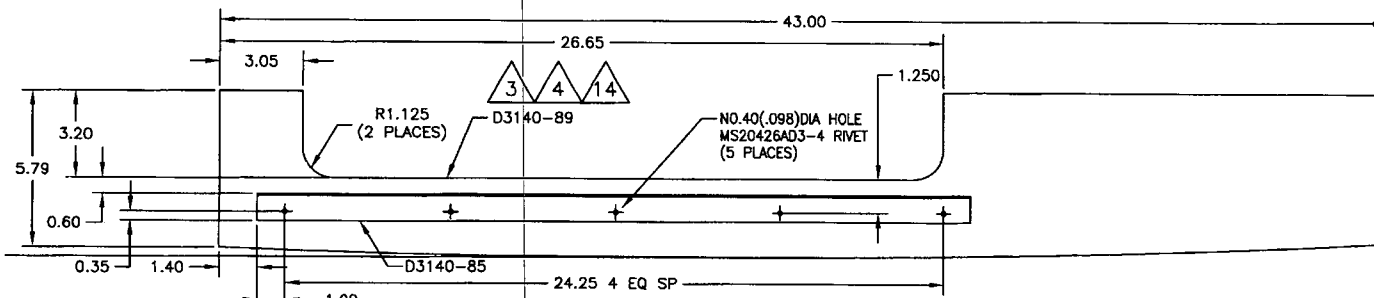
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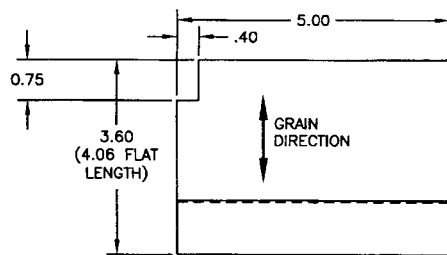
NOTE: Date & initial all entries

78723

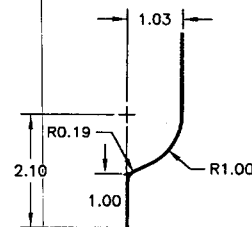


D3140-09 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-09)
D3140-10 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-10)

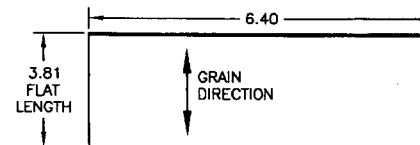
D3140-101 DOUBLER (4 14)
 (REPLACES PREMIER P/N B30-23000-101)



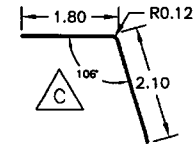
D3140-91F FLAT PATTERN
 (USE TO MAKE D3140-91/-92 DOUBLERS)



D3140-92 DOUBLER (4 14 F)
 (SHOWN, REPLACES PREMIER P/N B30-23000-92)
D3140-91 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-91)

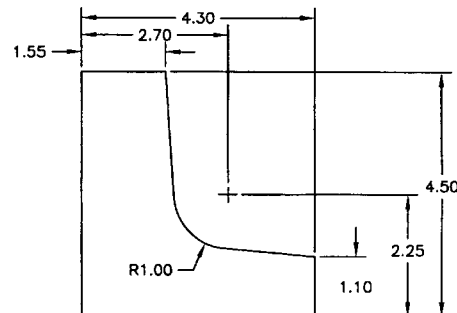


D3140-95 DOUBLER (4 14)
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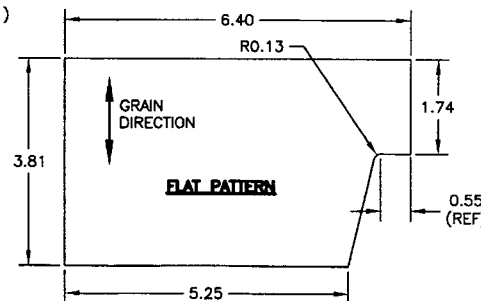


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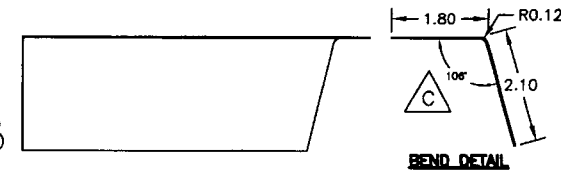
06.11.13



D3140-99 DOUBLER (4 14)
 (REPLACES PREMIER P/N B30-23000-99)



D3140-97F FLAT PATTERN
 (USE TO MAKE D3140-97/-98 DOUBLERS)



D3140-97 DOUBLER (4 14)
 (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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DESIGN 4	DRAWN BY CB	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED JH	APPROVED JH	DRAWING NO. D3140	REV. F SHEET 5 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	

W/O:		WORK ORDER CHANGES					
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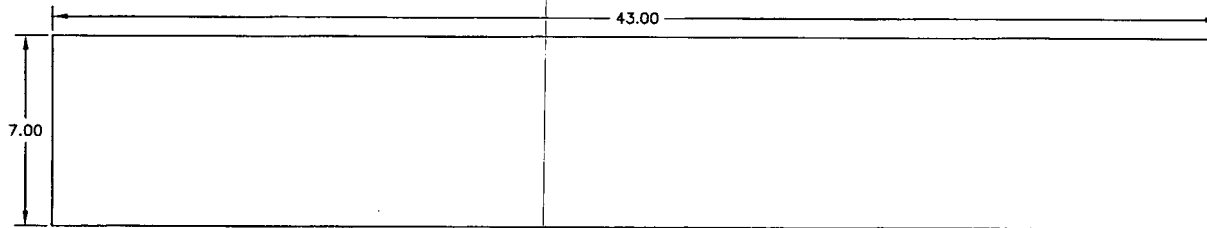
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

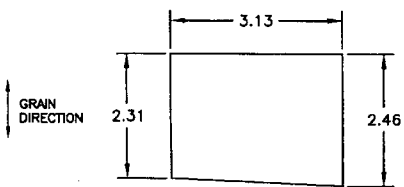
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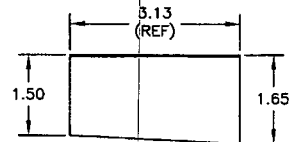
70723



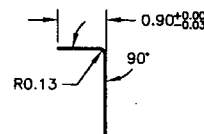
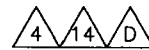
D3140-87 DOUBLER
(REPLACES PREMIER P/N B30-23000-87)



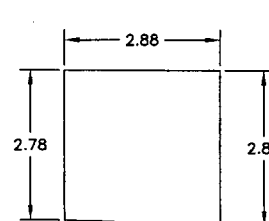
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



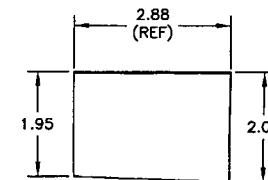
D3140-105 DOUBLER
D3140-106 OPPOSITE



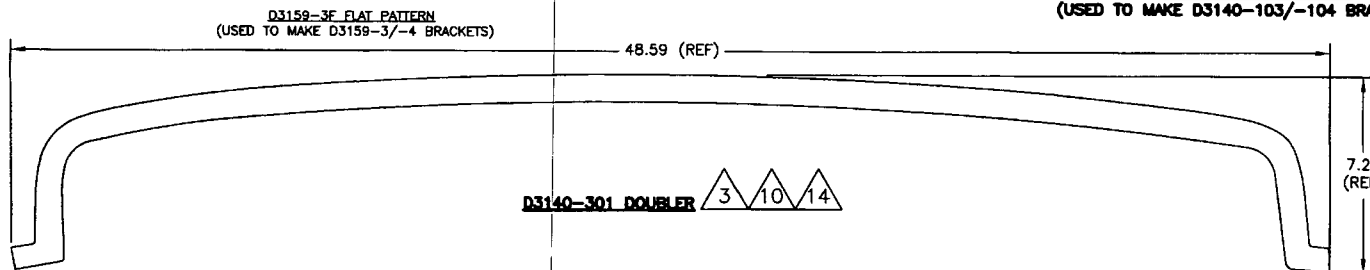
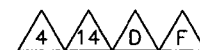
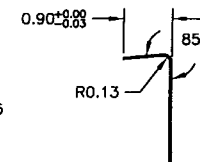
GRAIN DIRECTION



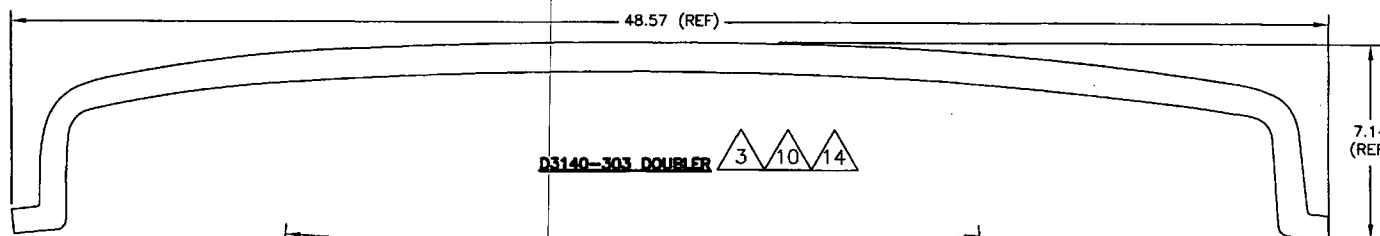
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



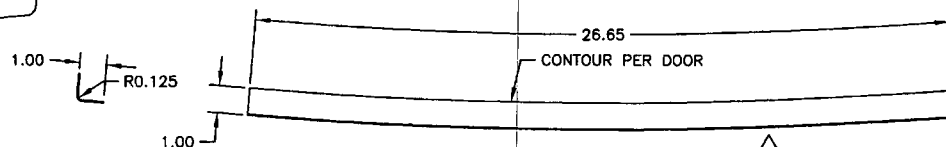
D3140-104 DOUBLER
D3140-103 OPPOSITE



D3140-301 DOUBLER



D3140-303 DOUBLER



D3140-85 ANGLE
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

RELEASED

2.11.13

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DESIGN	4	DRAWN BY	CB	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D3140	REV. F SHEET 6 OF 7
DATE	06.10.06	TITLE	DOOR	SCALE	NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

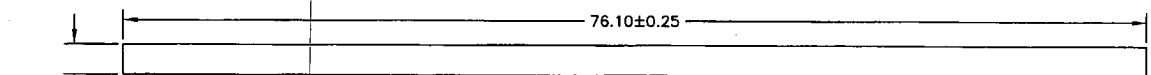
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

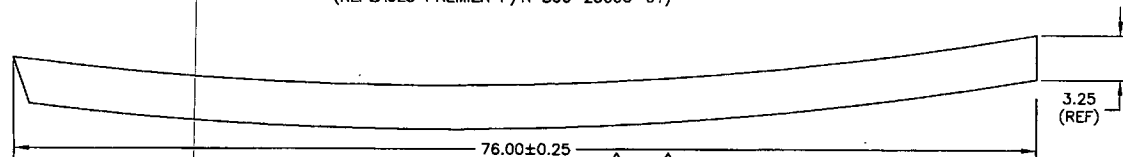
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

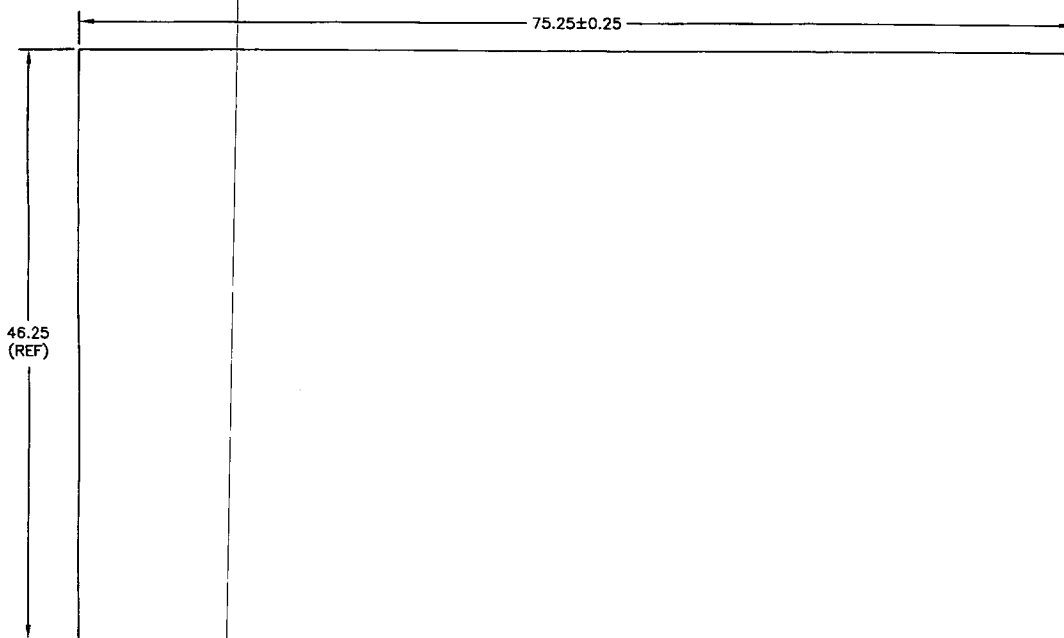
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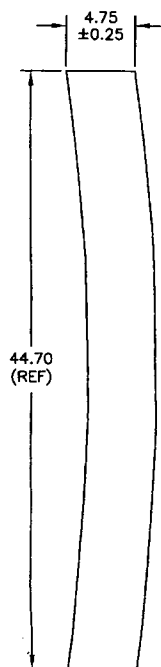
D3140-61 PAD 3 7
(REPLACES PREMIER P/N B30-23000-61)



D3140-63 PAD 3 7
(REPLACES PREMIER P/N B30-23000-63)

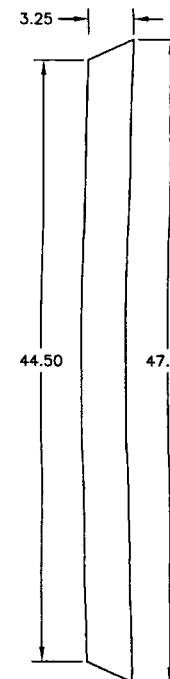


D3140-59 PAD 7
(REPLACES PREMIER P/N B30-23000-59)



D3140-57 PAD
(REPLACES PREMIER P/N B30-23000-57)

3 7



D3140-241 DOUBLER 5 14
(REPLACES PREMIER P/N B30-23000-241)

RELEASED

06.11.13

R1.00
(2 PLACES, REF)

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DESIGN	#	DRAWN BY	CB	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED		DRAWING NO. D3140	REV. F SHEET 7 OF 7
DATE	06.10.06	TITLE	DOOR	SCALE	NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries